



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-101
Job Sheet 174805



Part No: D119-796-101

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG DSI9730 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM IPP REV:B 14.10.22 AS PER PA1 DD VERF:JLM IPP REV:C 14.11.19 AS PER IIN REV:B DD VERF:JLM IPP REV:D 15.02.12 PER REV C JLM VERIFIED BY:DD IPP REV:E 15.05.13 PER REV D JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	4/23/18	4/23/18	0.00	0.00	Start Up Stores/Pkg-1			APR 25 2018
95	Crosstubes	1 pcs	4/24/18	4/24/18	0.00	10.00	Crosstubes-1			NM DAS
110	Packaging	1 pcs	4/24/18	4/24/18	0.00	0.00	Packaging1-1			APR 25 2018 6
120	QC	1 pcs	4/24/18	4/24/18	0.00	0.00	QC4			DAS 9-89
125	DC	1 pcs	4/24/18	4/24/18	0.00	0.00	DC			58
130	Packaging	1 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3-1			9-89 DAS
140	QC21-FG	1 Ea	4/24/18	4/24/18	0.00	0.00	QC21			58 9-89

Part Op 125 - Photocopy bluefile & type labels per PPP D119-796-101 CHG004
Descriptions: 130 - Identify and pack for shipping as per PPP D119-796-101

DAS
21
9-89

APR 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN5C32A	Bolt	4 Ea (4 ea)	90-Start up Operation	15/316 50
AN5C7A	Bolt	12 Ea (12 ea)	90-Start up Operation	5641128
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5063832
D3672-7	Washer, Phenolic	8 Ea (8 ea)	90-Start up Operation	509309
MS21043-5	Nut	4 Ea (4 ea)	90-Start up Operation	5084470
MS21250-05-048	Bolt	4 Ea (4 ea)	90-Start up Operation	5039031
NAS1149C0532R	Washer	8 Ea (8 ea)	90-Start up Operation	5055957
NAS1149C0563R	Washer	12 Ea (12 ea)	90-Start up Operation	FW138709-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN5C32A	4	74	0
	AN5C7A	12	128	0
	D119-796-151	1	2	0
	D3672-7	8	555	0
	MS21043-5	4	131	0
	MS21250-05-048	4	39	0
	NAS1149C0532R	8	373	0
	NAS1149C0563R	12	552	0

2284



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Container No: S064962



Part: D119-796-101

Job No: 174805

Serial No/Batch: S064962

Revision:
Inspector:

Date: 04/25/18

Part Specifications
Specifications could not be found.

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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002784	S064961	AN5C32A	Bolt	F131650	ST336	4
002784	S064960	AN5C7A	Bolt	S041128	ST338	12
002784	S064959	D3672-7	Washer, Phenolic	S019309	ST051A	8
002784	S064958	MS21043-5	Nut	S024470	ST302	4
002784	S064957	MS21250-05-048	Bolt	S039034	ST295	4
002784	S064956	NAS1149C0532R	Washer	s055951	ST266	8
002784	S064955	NAS1149C0563R	Washer	fm138409-2	ST265	12

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Description: FWD CROSSTUBE INSTALLATION WITH PEG STEPS

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2	8	8	8	8					D3672-7	WASHER
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4		4	4	D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12							2		D5149-041	FWD STEP ASSY
13								2	D5149-043	AFT STEP ASSY
14					2				D5152-041	FWD POST MOUNT ASSY
15						2			D5152-043	AFT POST MOUNT ASSY
16						2		2	D5515-1	GROUNDING CLAMP
17							2	2	AN174-3A	BOLT
18	12	12	12	12					AN5C7A	BOLT
19	4	4	4	4					AN5C32A	BOLT
20						16			CR3212-4-07	RIVET
21					16				CR3212-4-08	RIVET
22							4		MS21920-22	CLAMP
23					4				MS21920-24	CLAMP
24						6		4	MS21920-25	CLAMP
25		2		2		2			MS21920-28	CLAMP
26	4	4	4	4					MS21250-05048	BOLT
27						2		2	MS21042-3	NUT
28						2		2	MS21042-4	NUT
29	4	4	4	4					MS21043-5	NUT
30						2		2	MS27039-1-08	SCREW
31						4		4	NAS1149D0332J	WASHER
32						4		4	NAS1149D0432J	WASHER
33	8	8	8	8					NAS1149C0532R	WASHER
34	12	12	12	12					NAS1149C0563R	WASHER
100		1		1					DP460	SCOTCH WELD ADHESIVE (37mL)

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